

Work Order ID 84029

May-01-12 10:46:05 AM

slp today! 02/05

84029

Page 1

Item ID: D3538-1

Accept

N900040100

Setup Start

NS1

Revision ID:

Stop

NS2

Item Name: Hinge Bracket

Start Date: 01/05/2012 Start Qty: 10.00

10

Cust Item ID:

Required Date: 15/05/2012 Req'd Qty: 10.00

10

Customer:

Reference:

Approvals:

Process Plan: MLJ

Date: 12/05/01

Tooling:

Date:

Run Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr

Revision Nbr

D3538

Rev A

100

0.00

100

BAND SAW

2 12-5-1

10

4

Bandsaw

Memo

0.00

Jeaspa Bandsaw

Cut blanks 1.500" long

110

0.00

110

HAAS CNC VERTICAL MACHINING #1

2 12-5-1

10

4

HAAS 1

Memo

0.00

HAAS CNC vertical machine #1

1-Machine as per Folio FA651 and Dwg D35382-Deburr

120

0.00

120

QC2- Inspect parts off machine FAI/FAIB

2 12-5-1

10

4

QC

Memo

0.00

Quality Control

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 84029

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Page 2

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Item ID: D3538-1

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N900040100

Setup Start *NS1*

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Stop *NS2*

Item Name: Hinge Bracket

Start Date: 01/05/2012 Start Qty: 10.00

10

Cust Item ID:

Required Date: 15/05/2012 Req'd Qty: 10.00

10

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start *NR1*

QC:

Date:

SPC (Y/N):

Date:

Stop *NR2*

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

130

QC8- Inspect parts - second check

0.00

130

QC

Memo

0.00

Quality Control

B.A 12/05/02

10 0

140

Chemical Conversion Coat per QSI005 4.1

0.00

140

HandFinish

Memo

0.00

Hand Finishing

10 0 12-52

150

White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum

0.00

150

Powdercoat

Memo

0.00

Powder Coating

START TIME:

OVEN TEMPERATURE:

FINISH TIME:

3200F

11:30

10X 0 12/05/02

M121134

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 84029

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Page 3

May-01-12 10:46:05 AM

Item ID: D3538-1

Accept

N900040100

Setup Start ***NS1***

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Item Name: Hinge Bracket

Start Date: 01/05/2012 Start Qty: 10.00

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Cust Item ID:

Required Date: 15/05/2012 Req'd Qty: 10.00

10

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start ***NR1***

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

160

QC3- Inspect Part Finish

0.00

160

QC

Memo

0.00

Quality Control

10k d M 10/5/02

170

Identify as per dwg & Stock Location: S4

0.00

170

Packaging

Memo

0.00

Packaging

(10k) 12/5/02

180

QC21- Final Inspection - Work Order Release

0.00

180

QC

Memo

0.00

Quality Control

M 12/05/02
MF 12-05-02

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

May-01-12 10:46:09 AM

Page 1

Work Order ID: 84029

84029

Parent Item: D3538-1

D3538-1

Parent Item Name: Hinge Bracket

Start Date: 01/05/2012

Required Date: 15/05/2012

Start Qty: 10.00

Required Qty: 10.00

Comments: IPP Rev:A New Issue 06-10.03 EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M6061T6B1.250X01.25 0		Purchased	No			100	f	28.7400	0.19	2			

M6061T6B1 250X01 250

**

2 12-5-1

6061-T6 Bar 1.25 x 1.25

Location

Loc Qty

Loc Code

MAT004

28.74

119318

28.74

1.25

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order:	84029
Description: Hinge Bracket		Part Number:	D3538-1
Inspection Dwg: D3538 Rev: A		Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype 686

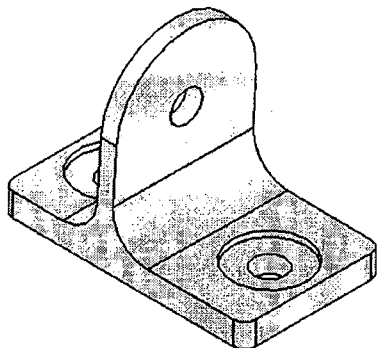
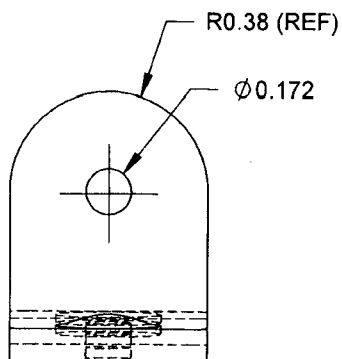
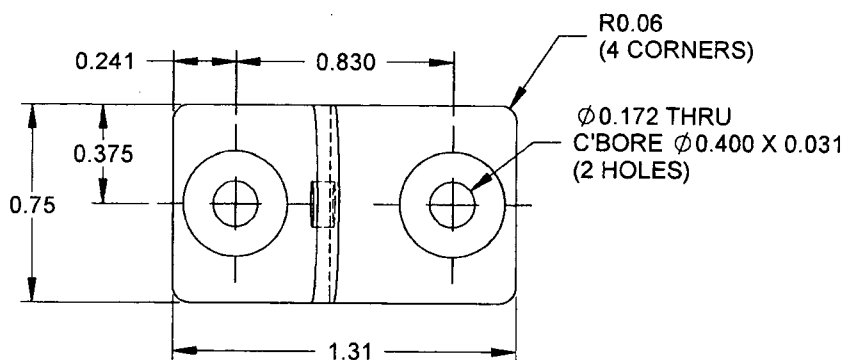
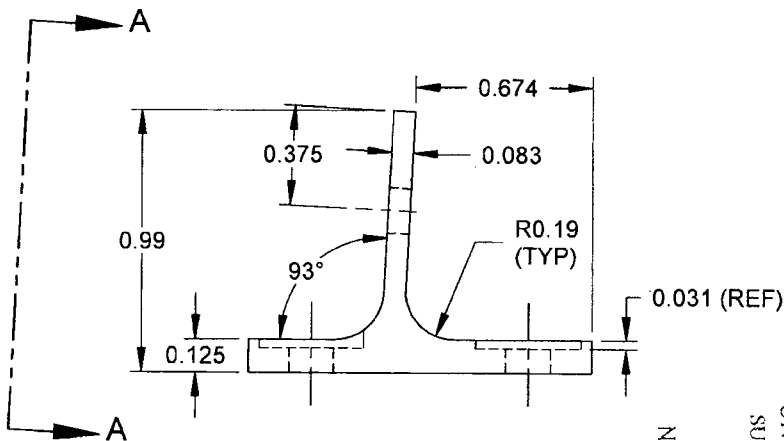
Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
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0.375	+/-0.010	.377	/			
0.241	+/-0.010	.244	/			
0.830	+/-0.010	.828	/			
Ø0.172	+0.005/-0.001	.172	/			
Ø0.400	+0.006/-0.001	.398	/			
0.031	+/-0.010	.028	/			
1.31	+/-0.030	1.314	/			
0.375	+/-0.010	.375	/			
0.99	+/-0.030	.987	/			
0.125	+/-0.010	.131	/			
R0.19	+/-0.030	.188	/			
0.083	+/-0.010	.085	/			
93°	+/-0.5°	93°	/			
0.674	+/-0.010	.667	/			
R0.38	+/-0.030	.375	/			
Ø0.172	+0.005/-0.001	.172	/			

Measured by: PT	Audited by: B.A	Prototype Approval:	N/A
Date: 12.5.2	Date: 12/05/02	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	07.05.31	New Issue	KJ/JLM	

DART

DESIGN <i>LE</i>	DRAWN BY <i>LE</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>PH</i>	APPROVED <i>#</i>	DRAWING NO. D3538	REV. A SHEET 1 OF 2
DATE 06.10.13	TITLE HINGE BRACKET		SCALE 1:1
REV A	DATE 06.10.13	DESCRIPTION NEW ISSUE	

**RELEASED**
06.10.13 #**AUXILIARY VIEW A****D3538-1 HINGE BRACKET**

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 84029 M.C.S
12/65/01

NOTES:

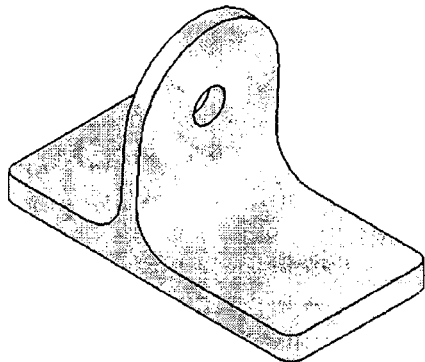
- 1) MATERIAL: 6061-T6 ALUMINUM PER QQ-A-225/8 OR QQ-A-200/8 (REF DART SPEC M6061T6B)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
- 5) BREAK ALL SHARP CORNERS TO 0.010 MAX
- 6) IDENTIFY WITH P/N D3538-1 USING FINE POINT PERMANENT INK MARKER

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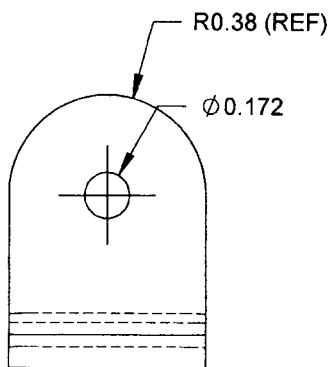
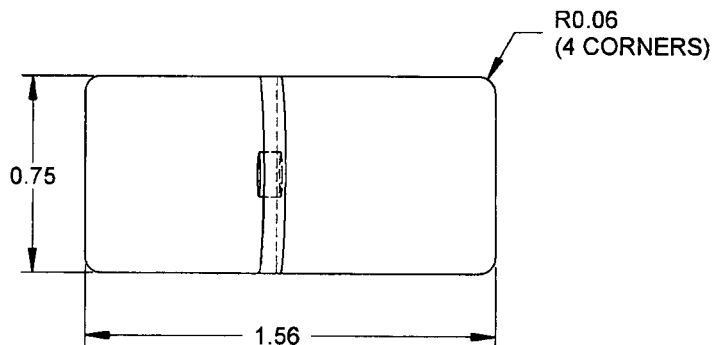
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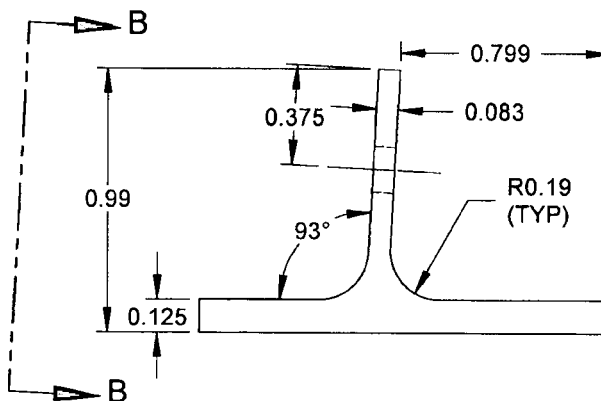
DESIGN <i>LE</i>	DRAWN BY <i>LE</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>PH</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3538	REV. A SHEET 2 OF 2
DATE 06.10.13	TITLE HINGE BRACKET		SCALE 1:1



RELEASED
06.10.13



AUXILIARY VIEW B



D3538-3 HINGE BRACKET

NOTES:

- 1) MATERIAL: 6061-T6 ALUMINUM PER QQ-A-225/8 OR QQ-A-200/8 (REF DART SPEC M6061T6B)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
- 5) BREAK ALL SHARP CORNERS TO 0.010 MAX
- 6) IDENTIFY WITH P/N D3538-3 USING FINE POINT PERMANENT INK MARKER

84029

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